

Work Order ID 101352

May-08-13 9:55:59 AM

101352

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Item ID: DSI 9652-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bolt Substitution

Start Date: 5/08/13 Start Qty: 8.00

8

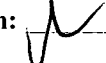
Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9644	A								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP DSI 9652-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 06 13/5/8 (8X)

8x 13-5-8 (8X)

DAS 06 13/5/8 (8X)

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Item ID: DSI 9652-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bolt Substitution
 Start Date: 5/08/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 5/08/13 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9652-011 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
006
9-08

84

8

13-05-08

ML5

130508

ML5 13-05-08

Picklist Print

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Work Order ID: 101352

Parent Item: DSI 9652-011

Parent Item Name: Bolt Substitution

Start Date: 5/08/13

Required Date: 5/08/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.05.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21250H05006

BOLT

Purchased

No

Each

0.0000

8x 64

m 125549

SP 13-5-8

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1

REF. FAA STC: SR02024SE

REF. EASA STC: 10040294

REFERENCE ONLY

13/5/8 S

1.0 PURPOSE

To provide an alternate fastening method to secure the D119-646-XXX skid tubes to the aircraft cross tubes.

2.0 INSTALLATION OPTION

The MS21250-05006 Bolts can be replaced with MS21250H05006 and lockwired with MS20995C47 (customer supplied) in accordance with MS33540 or AC 43.13. Refer to Figure 1 of this service instruction for reference. The torque on the MS21250H05006 should be limited to 65-85 in-lbs (7.3-9.6 N-m).

3.0 PROCUREMENT

The DSI 9652-011 Bolt Substitution kit can be procured from DART Aerospace. One kit modifies one skid tube.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9652-011	BOLT SUBSTITUTION
8	MS21250H05006	BOLT

A	NEW ISSUE	MB	13.04.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9652	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT SUBSTITUTION	NTS
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